

Date: Tuesday, 3/11/2008 11:25:26 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG WELDMENT
Job Number	: 37787		
Estimate Number	: 12118		
P.O. Number	:	Part Number	: D3353042
This Issue	: 3/11/2008 S.O. No. :	Drawing Number	: D3353 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 34666	Material	:
Written By	:	Due Date	: 4/10/2008 Qty: 4 Um: Each
Checked & Approved By	: <u>H 08 03 11</u>		
Comment	: est rev A 06.01.26 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D335311	universal joint
-----	---------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3353-11	universal joint	* B31585

Pl 09.01.07

2.0	D33535	back plate
-----	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3353-5	back plate	B34680V

Pl 09.01.07

3.0	D335313	tubing
-----	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3353-13	tubing	B30454 → 3*
			B34676 → 1V

Pl 09.01.07

4.0	D335317	support
-----	---------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3353-17	support	B42493V

Pl 09.01.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 11:25:26 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 37787

Part Number: D3353042

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D33533

right plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

pick:

qty	part number	description
1	D3353-3	right plate

batch

B34879✓

Pl 09.01.07

6.0

D33539

STOP PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

pick:

qty	part number	description
1	D3353-9	stop plate

batch

B30459✓

Pl 09.01.07

7.0

D33531

left plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

pick:

qty	part number	description
1	D3353-1	left plate

batch

B30453 → 2✓
B37936 → 2✓

Pl 09.01.07

8.0

D33537

front plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

pick:

qty	part number	description
1	D3353-7	front plate

batch

B30178 → 3✓
B34681 → 1✓

Pl 09.01.07

9.0

D335315

lock bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

pick:

qty	part number	description
1	D3353-15	lock bracket

batch

B42492 → 4✓

Pl 09.01.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 11:25:26 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 37787

Part Number: D3353042

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(x4)

Comment: LARGE FABRICATION RESOURCE 1
Weld assembly as per dwg D3353

Plc 09-01-08 / EL 7-1-8

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 9-1-9 (4K)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/01/09 (4)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
1-Mask part as per dwg D3353

2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

9/1 09-01-12 (4)

12/11/2009
S.039 11:56
#1 324.1 F
#2 F
#3 F
#4 F

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FE 09/01/12 (4)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

ST 490 09/01/12 (4)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/13

Job Completion



MF 09-01-13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

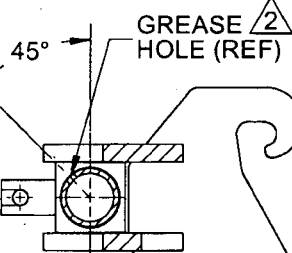
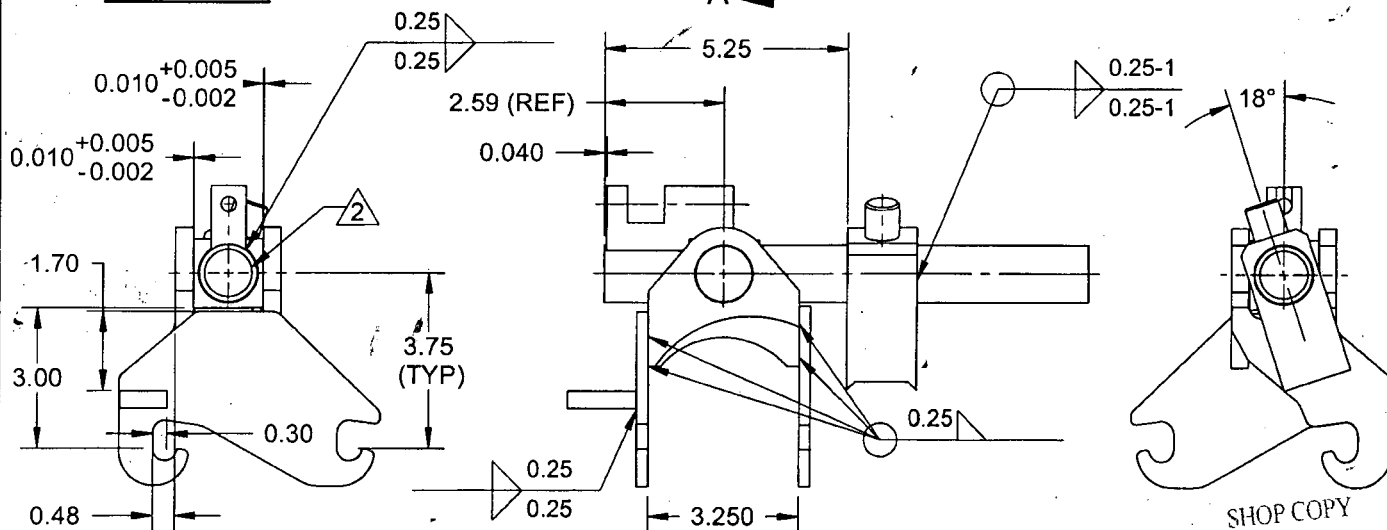
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:4
A	04.12.14	NEW ISSUE	

RELEASED
05/07/14

D3353-15 LOCK BRACKET (1)
D3353-7 FRONT PLATE (1)
D3353-1 LEFT PLATE (1)
D3353-9 STOP PLATE (1)
D3353-11 UNIVERSAL JOINT (1)
D3353-5 BACK PLATE (1)
D3353-13 TUBING (1)
D3353-17 SUPPORT (1)
D3353-3 RIGHT PLATE (1)

**SECTION A-A****D3353-041 LUG WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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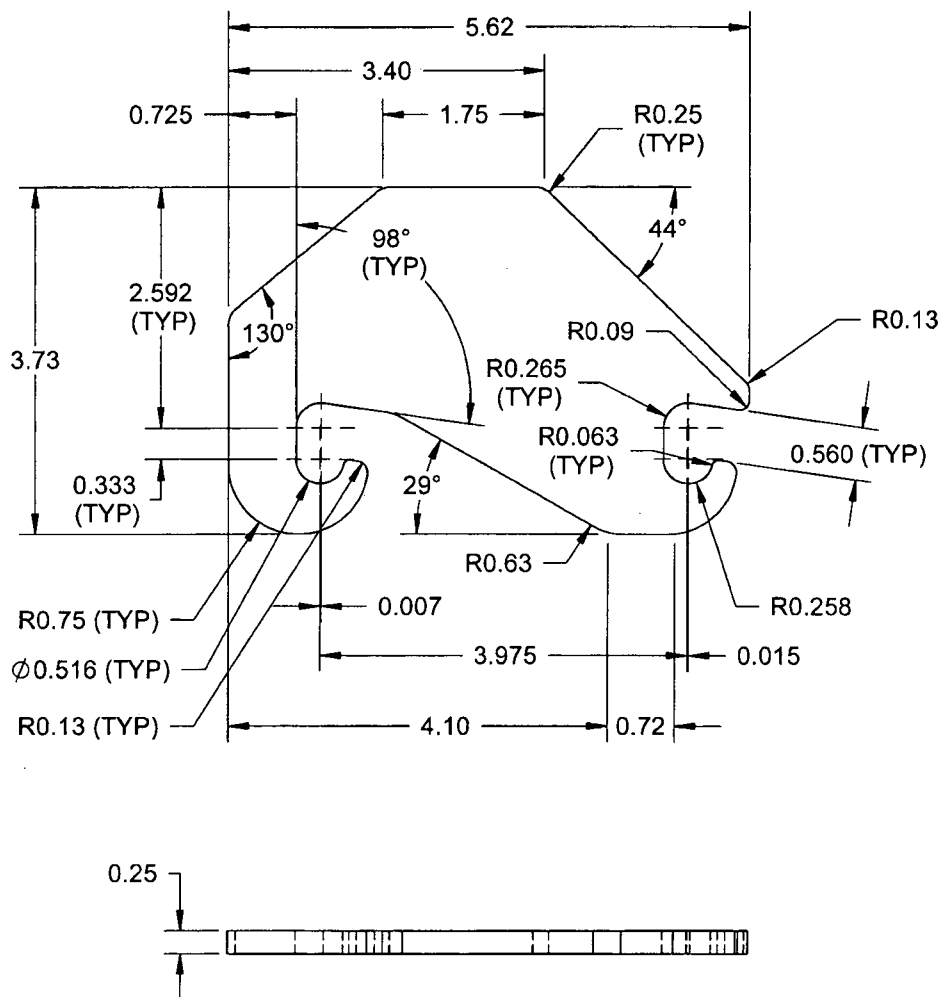
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:2

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01/07/14



D3353-1 LEFT PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

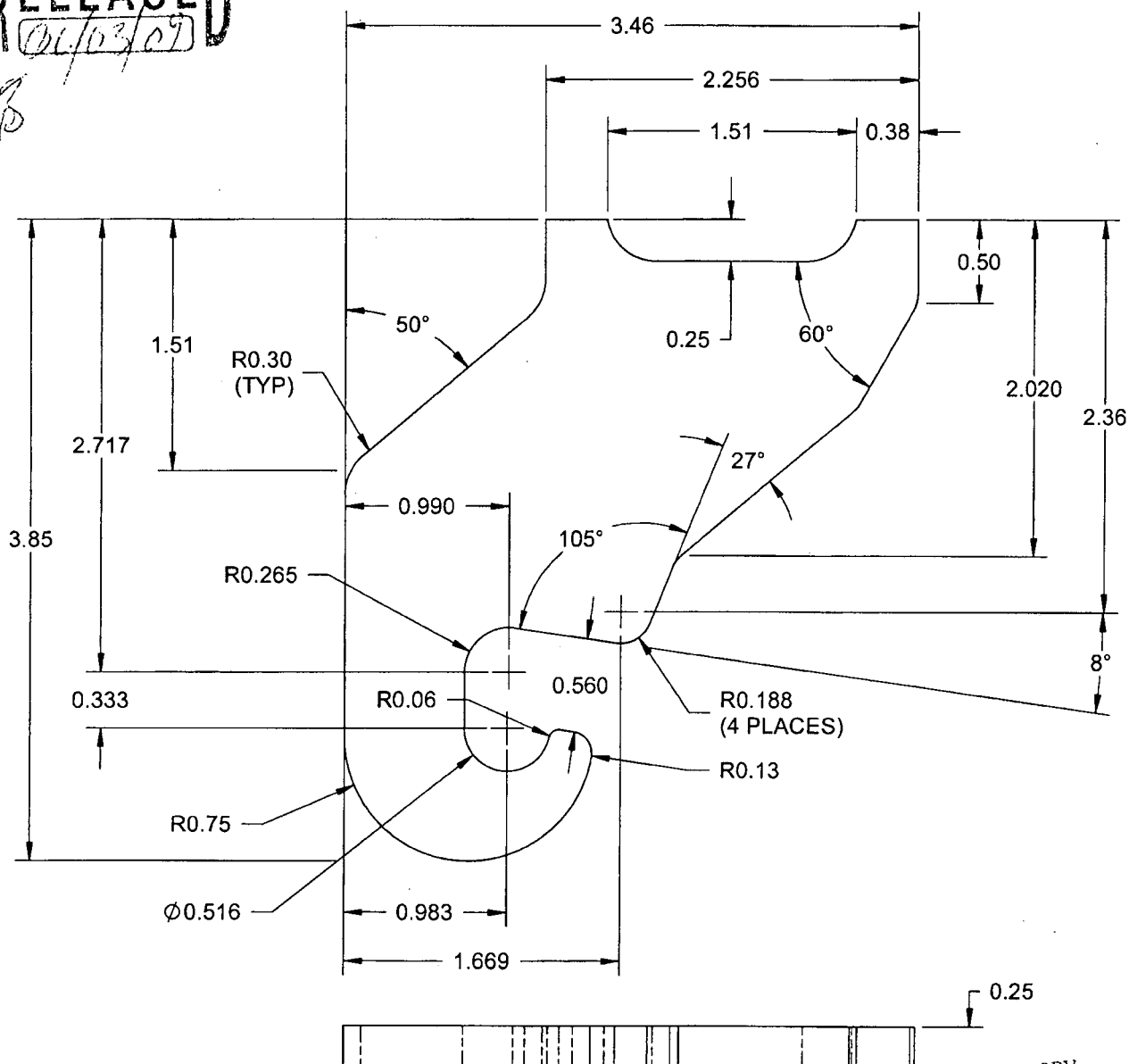
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED
06/03/09**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
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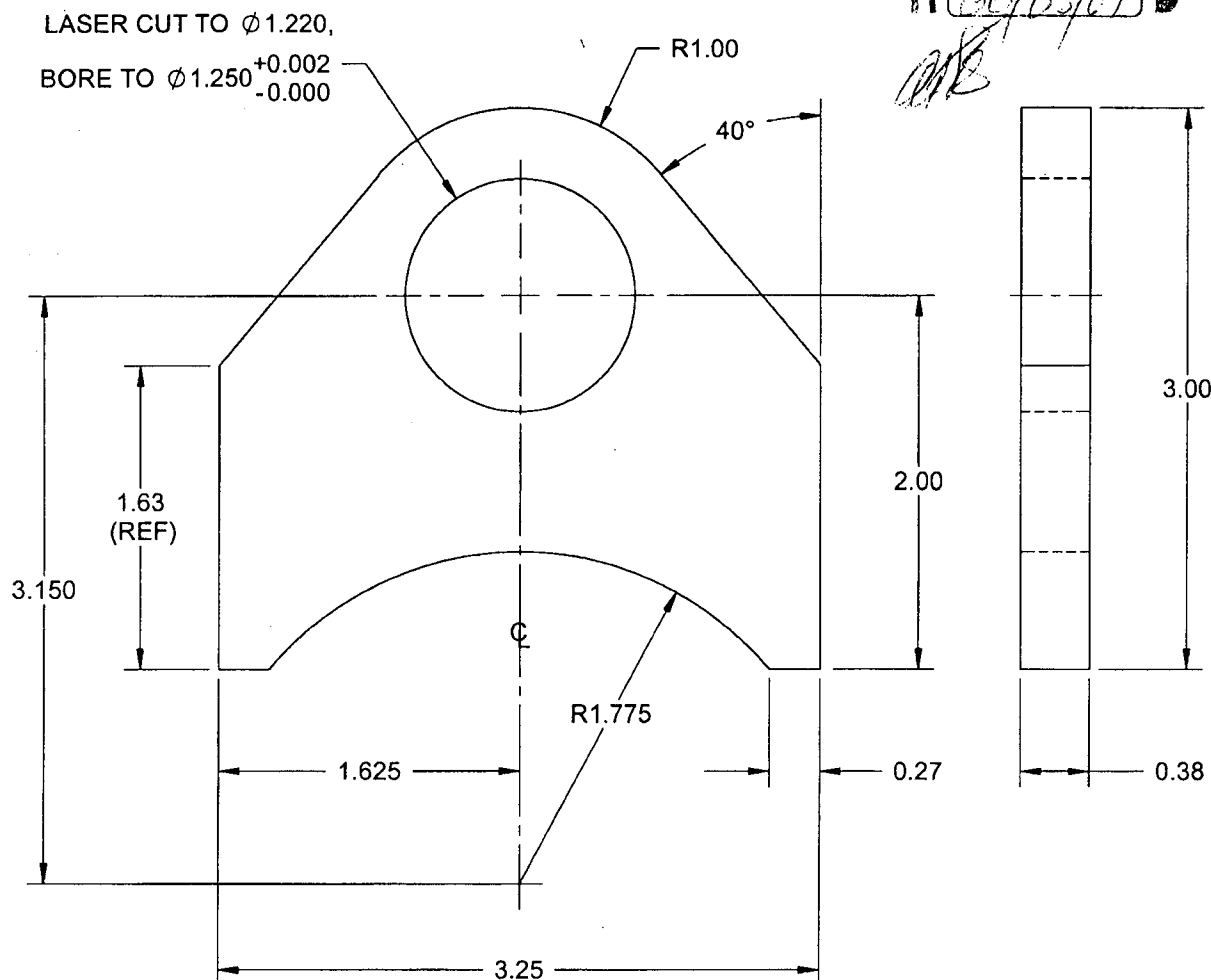
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED
06/03/09



D3353-5 BACK PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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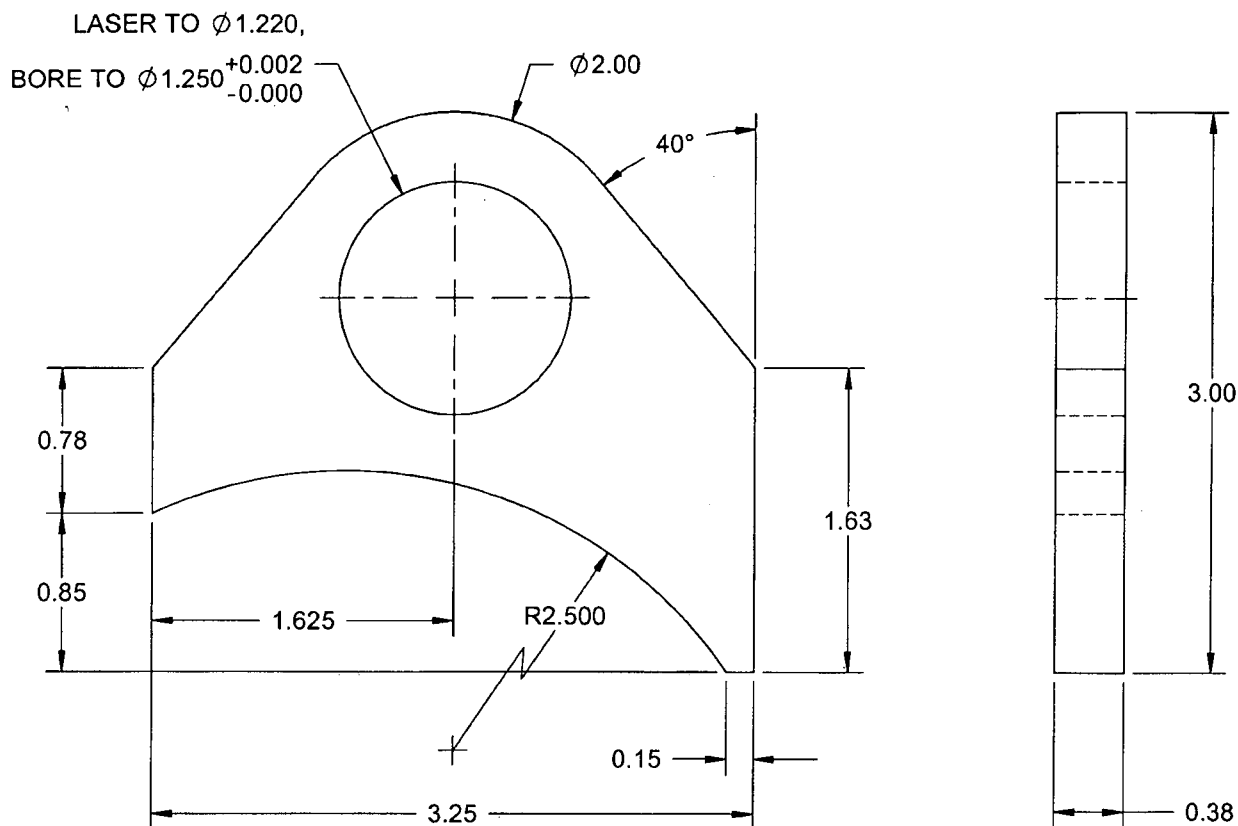
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

RELEASED
06/03/07



D3353-7 FRONT PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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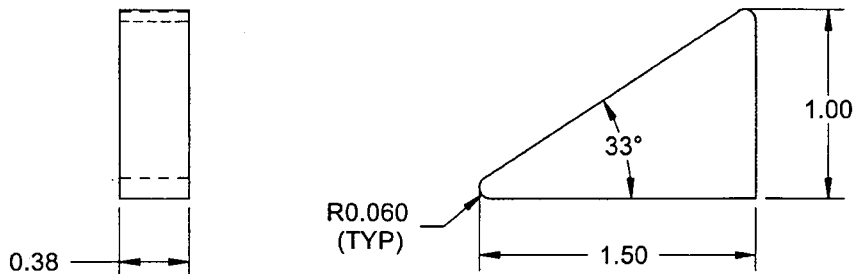
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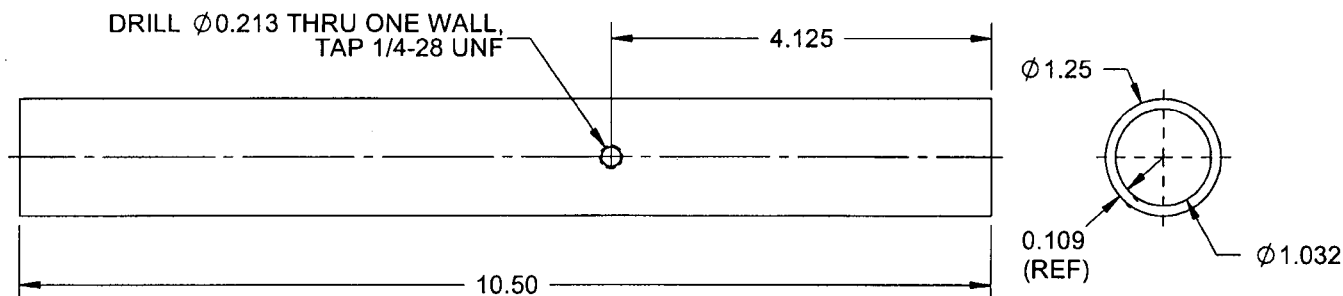
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6/3/04

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D3353-9 STOP PLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK
MILD STEEL BAR (REF. DART SPEC. M1010-B)



D3353-13 TUBING

NOTES:

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,
Ø1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING
(REF. DART SPEC. M1020TR1.250W.109)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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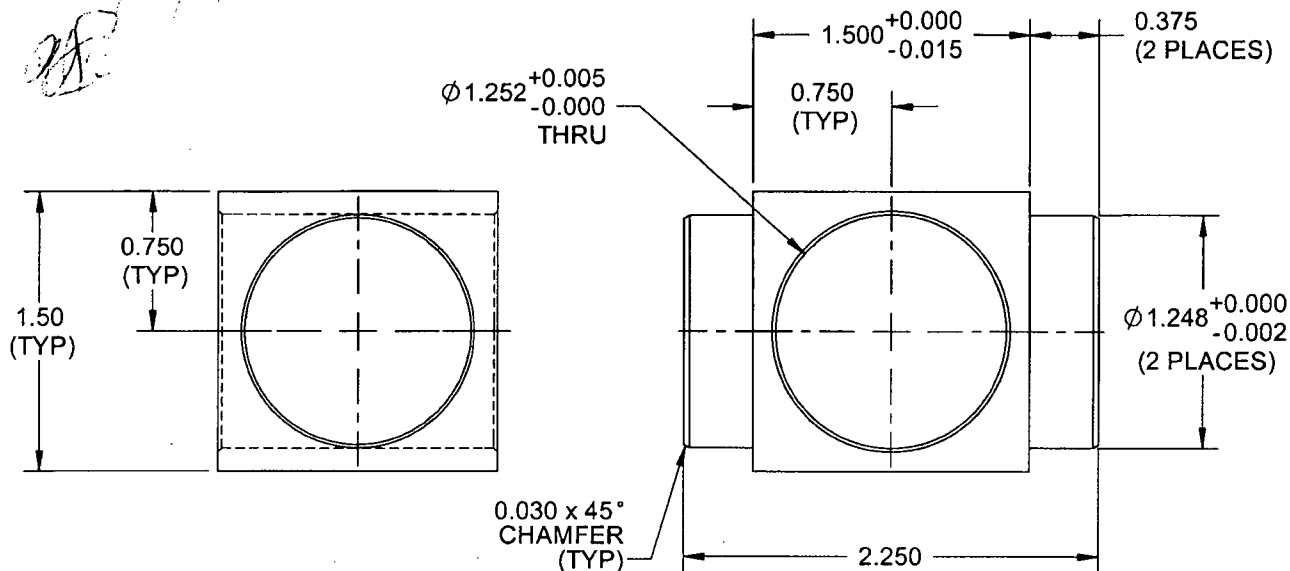
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

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06/33/09



D3353-11 UNIVERSAL JOINT

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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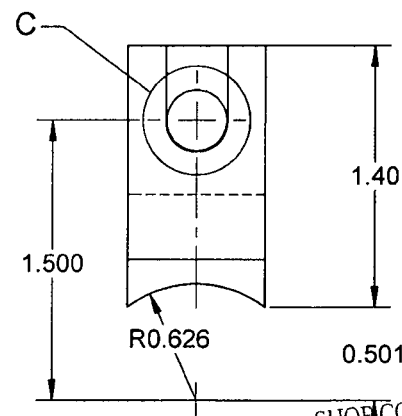
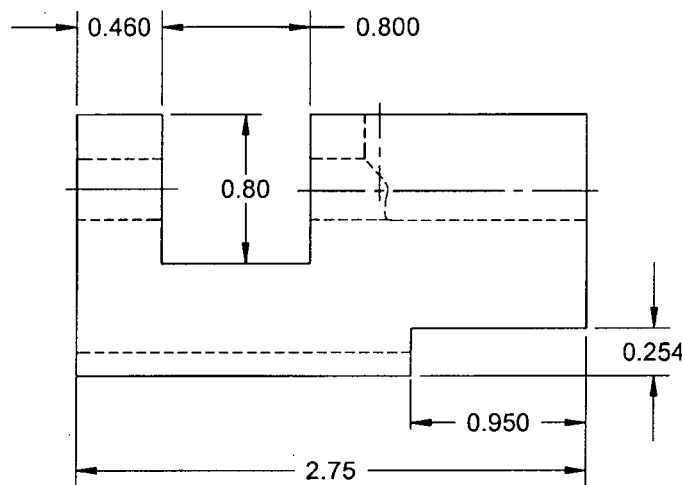
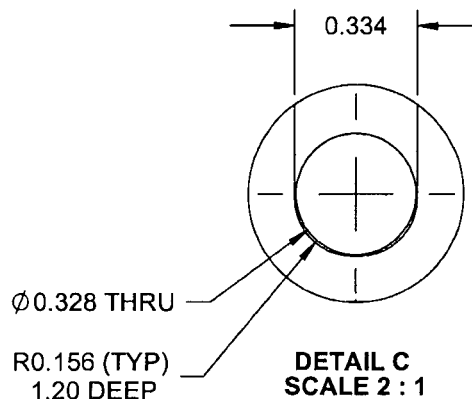
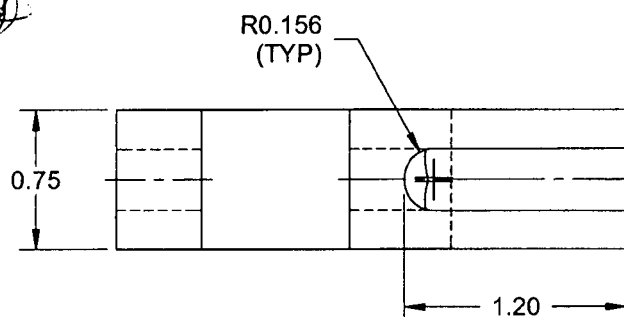
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03/02/09

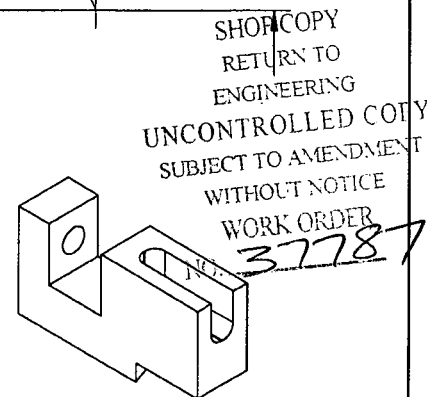
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D3353-15 LOCK BRACKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020



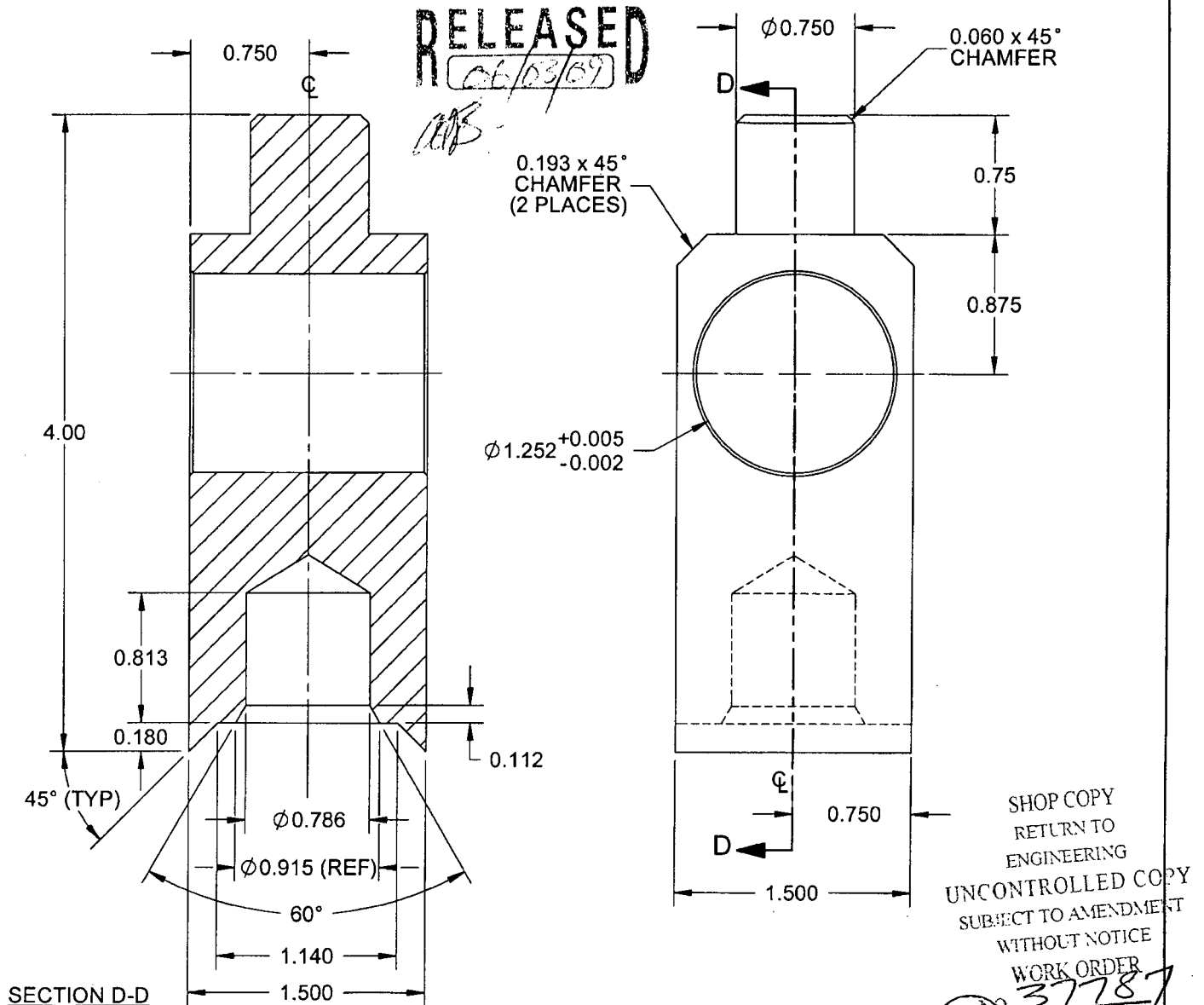
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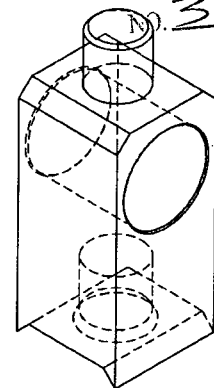
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

**D3353-17 SUPPORT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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